



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D4775-041
Job Sheet 186905



Part No: D4775-041

Job Qty: 10 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

228

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/10/18	0.00	0.00	Start Up Stores/Pkg-1		JAN 07 2019
110	Packaging	10 pcs		12/10/18	0.00	0.00	Packaging1-5		JAN 07 2019
120	Small Fab	10 pcs		12/10/18	0.00	4.15	Small Fab-7		JAN 07 2019
130	QC	10 pcs		12/10/18	0.00	0.00	QC5		JAN 08 2019
140	Packaging	10 pcs		12/10/18	0.00	0.00	Packaging3-2	ST357	JAN 08 2019
150	QC21-SA	10 Ea		12/10/18	0.00	0.00	QC21		JAN 08 2019

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: 13896 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

sup 6/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	20 Ea (2 ea)	90-Start up Operation	513685x3 5132304
D4775-1	Strut Tube	10 Ea (1 ea)	90-Start up Operation	5136801
D4776-1	Basket Strut Clevis	10 Ea (1 ea)	90-Start up Operation	5136799
D4776-5	Spacer	40 Ea (4 ea)	90-Start up Operation	5136821
D4777-1	Rod End Bearing	10 Ea (1 ea)	90-Start up Operation	5137348
MS21042L3	Nut	20 Ea (2 ea)	90-Start up Operation	5132364
MS21209-F615	Heli-Coil	10 Ea (1 ea)	90-Start up Operation	5131187

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	20	144	0
	D4775-1	10	0	0
	D4776-1	10	25	0
	D4776-5	40	76	0
	D4777-1	10	34	0
	MS21042L3	20	2,273	0
	MS21209-F615	10	46	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____ Step #: _____ QTY Effective : _____ MRR (OSI042) Approval _____

Description Work Order Deviation	Disposition

DART AEROSPACE

Container No: S142216

Part: D4775 - 041

Job No: 186905

Serial No/Batch: S142216

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 01/07/19

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Email: sales@dartaero.com
www.dartaerospace.com

Root Cause			FAULT CATEGORY		
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Supply	
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date ☐	☐ Manufacturing Process				
Misidentified ☐	☐ Past Due	☐ OTHER :			

Specifications could not be found.

Plex 11/22/18 12:56 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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